

Date: Tuesday, 4/25/2006 1:55:32 PM
 User: Kim Johnston

5817

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLADE FITTING
 Job Number : 26839
 Estimate Number : 12300
 P.O. Number : NIA Part Number : D3488042
 This Issue : 4/25/2006 S.O. No. : NIA Drawing Number : D3488 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 26190 Material : NIA
 Due Date : 5/20/2006 Qty: 20 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.04.25
 Comment : Est Rev:A New Issue 06-02-28 JLM
 Est Rev:B As per Rev B 06-03-30 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6103003 alum billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Alluminum Round Billet D6103-003

Batch: 325806

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Dwg DSK 101 & Folio FA627

2-Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G

06/05/30

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA627 & Dwg D3488

2-Deburr

J.G

06/05/30

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G

06/05/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 1:55:32 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 26839

Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Ep 06/05/13

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06/06/14
H-M 06/06/14

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/19

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06/06/20

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert M100489

DL 06/06/24

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

DL 06/06/24

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MM 06/06/26

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP23

a.m 06-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AB Date: 06/06/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 1:55:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 26839

Part Number: D3488042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/06/27 (21)
U 06-06-28

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26839
Description: Blade Fitting, RH		Part Number:	D3488-2
Inspection Dwg: D3488	Rev: B	Page 1 of 1	

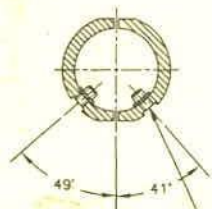
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.125	✓			
2.620	+/-0.010	2.621	✓			
0.793	+/-0.010					Remove cannot measure correctly.
1.351	+/-0.010	1.348	✓			
1.317	+/-0.010	1.321	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.802	✓			
Ø0.508	+0.006/-0.001	0.508	✓			
R0.062	+/-0.010	R0.062	✓			
1.500	+/-0.010	1.499	✓			
8.000	+0.030/-0.000	8.006	✓			
11.18	+/-0.030	11.179	✓			
Ø0.484	+0.005/-0.001	0.484	✓			
1.180	+/-0.010	1.180	✓			
3.150	+/-0.010	3.150	✓			
3.070	+/-0.010	3.069	✓			
0.590	+/-0.010	0.589	✓			
0.125	+/-0.010	0.120	✓			
1.005	+/-0.010	1.005	✓			
3.500	+/-0.010	3.498	✓			
Ø0.297	+0.005/-0.000	0.297	✓			
Ø0.430	+/-0.010	0.425	✓			
0.100	+/-0.010	0.095	✓			

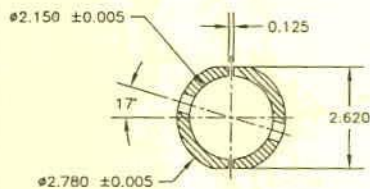
Measured by: J.G	Audited by: En	Prototype Approval:	N/A
Date: 06/05/31	Date: 06/05/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	



SECTION B-B

0.297
C'BORE 0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



SECTION A-A

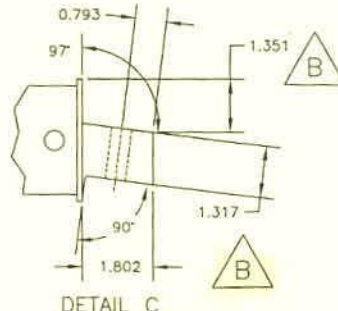
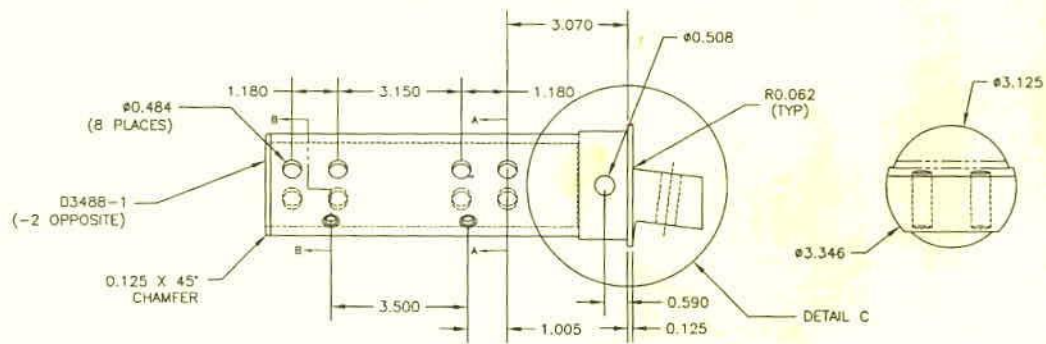
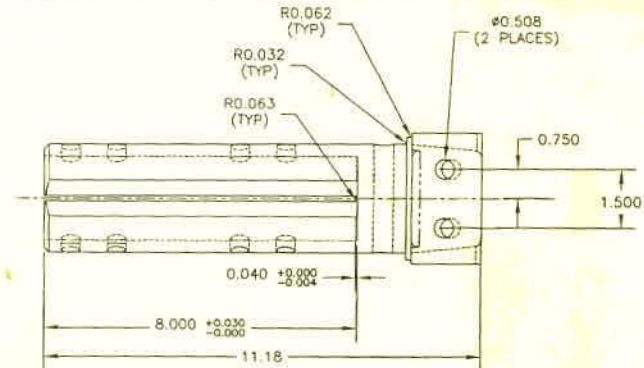
D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
		D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR
PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO 26839
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO APPROVEMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15
REV. 05
ECN #737

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
		BLADE FITTING
		REV. B
		SHEET 1 OF 1
		SCALE
		1:3

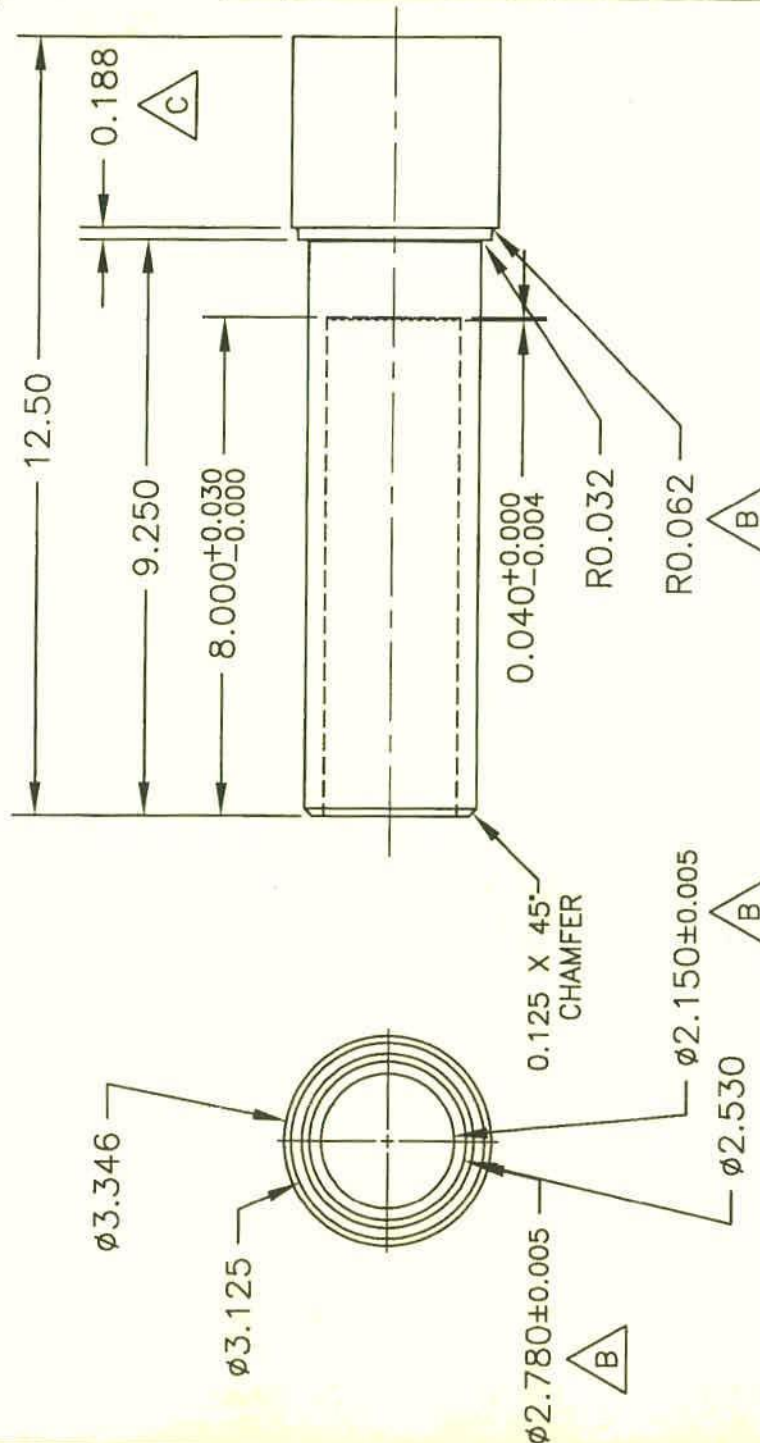
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DART AEROSPACE USA, INC.

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 101	REV. C SHEET 1 OF 1
DATE 06.04.17		TITLE D3488-1/-2 TURNING DETAIL	SCALE 1:3
A	05.12.21	NEW ISSUE	
B	06.03.02	ADD TOLERANCES AND RADIUS	
C	06.04.17	WIDEN TO 0.188 WAS 0.125	



- DSK 101
- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: NONE
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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26839



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
46	DSK101	Blade Fitting	1110

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, May 24, 2006

